

# Work Order ID 56484

February 24, 2010 1:48:03 PM

Page 1

Item ID: D3281-1

Revision ID:

Item Name: Floor Protector, Fwd LH

Start Date: 2/24/10 Start Qty: 2.00

Required Date: 2/25/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3281

DEO E-1

100

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

HAND FINISHING THERMOFORMING

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

THERMOFORMING MACHINE

Thermoform as per Dwg. D3281 and Folio FTA 011 Dwg. Rev.

PRELIM Folio Rev. B

120

0.00



QC

Memo

0.00

Quality Control

QC2- Inspect parts off machine FAI/FAIB



Setup Start

Stop

Cust Item ID:

Customer:



DL 10/02/24 (X2)


DAY @ TIME IN 4:10 pm DL  
355F TIME OUT 6:30 AM DL  
10/02/25 (X2)

Temp @ 335F  
Mould @ 230F DL 10/02/25 (X2)  
Release @ 270F

DL 10/02/25 (X2)

PRELIMINARY ISSUE

Accept

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.02.25	130	ENGRAVE PIN "D3281-1 LOG"	IL	10/02/25		 10.02.25 PC 051012	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 56484

February 24, 2010 1:48:03 PM

Page 2

Item ID: D3281-1CL

Accept

Revision ID:

Item Name: Floor Protector, Fwd LH

Start Date: 2/24/10 Start Qty: 2.00

Required Date: 2/25/10 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

Trim to Finished Dimensions

0.00

0.00

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

From 24 to prelim

0.00

0.00

**QC APPROVAL**

2

BB  
10/02/25  
X2

BB  
10/02/25

1002-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56484

February 24, 2010 1:48:04 PM

Page 3

Item ID: D3281-1CL

Revision ID:

Item Name: Floor Protector, Fwd LH

Start Date: 2/24/10 Start Qty: 2.00

Required Date: 2/25/10 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Packaging

Packaging

Packaging

Memo

0.00

0.00

W/O 56514

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

POSITIVE RECALL

EFFECTIVE 2/24/10

RELEASED 2/24/10

AUTH

DATE

10.02.26

W/O 56514

10/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 24, 2010 1:48:02 PM

Page 1

Work Order ID: 56484

Parent Item: D3281-1CL

Parent Item Name: Floor Protector, Fwd LH

Comments: IPP Rev. A 10.02.24 New Issue LL

Start Date: 2/24/10

Required Date: 2/25/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No				sf	2,818.330	8.6666			



Lexan Sheet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

2818.33

111588

98.33

113127

2720

9.8 ~~38~~ 4.

OK 10/02/24.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 52484
<b>Description:</b> Floor Protector, Fwd LH		<b>Part Number:</b> D3281-1CL
<b>Inspection Dwg:</b> D3281	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

**Measured by:** Wh **Date:** 10/02/25

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	18.6	✓			
17.1	+/-0.100	17.1	✓			
11.7	+/-0.100	11.7	✓			
0.95	+/-0.030	0.972	✓			
0.25	+/-0.030	0.257	✓			
0.030	Min	0.052	✓			
0.070	Min	0.105	✓			

**Measured by:** BB **Date:** 10/02/25

**Audited by:** Wh **Date:** 10/03/25

**Prototype Approval:** N/A **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	

DRAWING NO. D3281	TITLE FLOOR PROTECTOR	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3281-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>q</i>	MFG. APPR.	APPROVED		DE APPR.		
DATE 10.02.24	DATE 10.02.24	DATE	DATE		DATE		

### PURPOSE

ADD "D3281-xKCL" MATERIAL OPTION.

### CHANGE

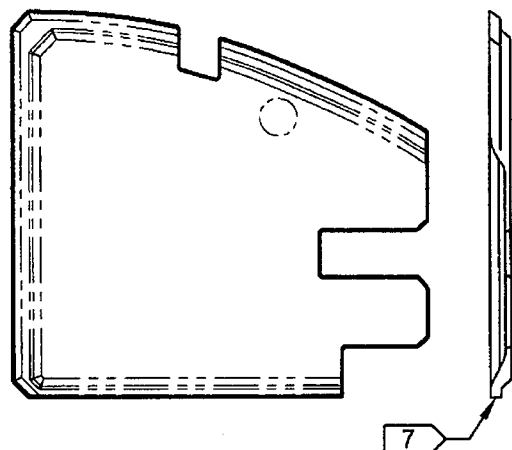
D3281-xKCL PARTS ARE EQUIVALENT TO THE RESPECTIVE "-x" PARTS, HOWEVER THE MATERIAL AND IDENTIFICATION NOTES ARE AMENDED AS FOLLOWS:

2) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR  
(MLEXS.118-90318-08)

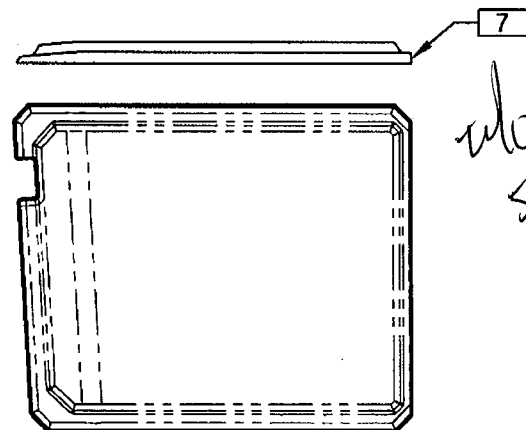
7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-xKCL" AND B/N "Bxxxxx" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS.  
LOCATE ENGRAVING ALONG PERIMETER OF PART.

**PRELIMINARY ISSUE**

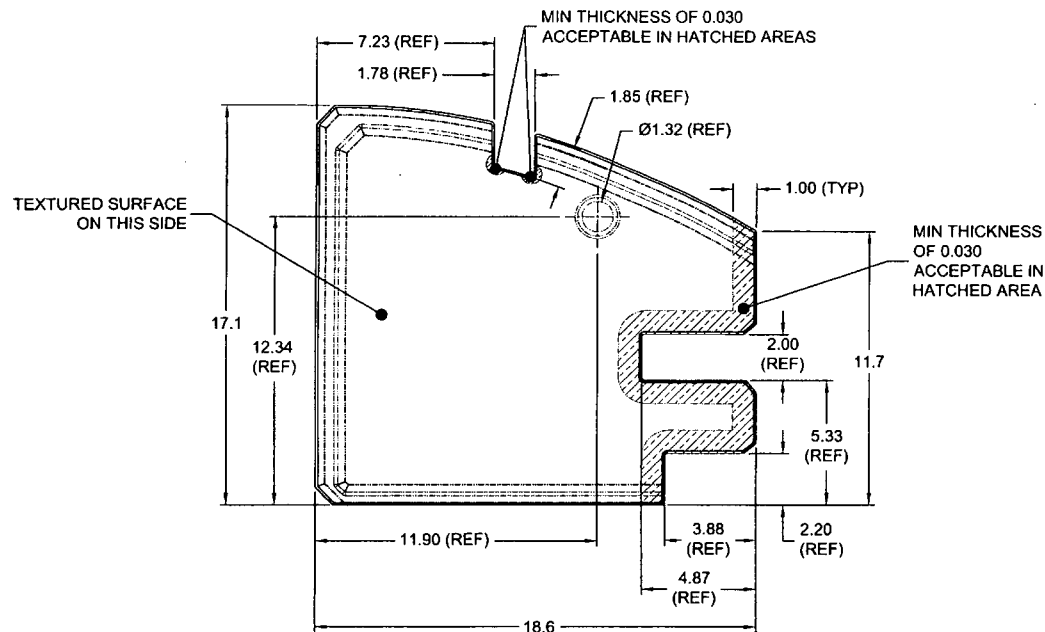
*q 10.02.24*



**D3281-1KCL FLOOR PROTECTOR (SHOWN)**  
**D3281-2KCL FLOOR PROTECTOR (OPPOSITE)**  
LOCATION OF ENGRAVING



**D3281-3KCL FLOOR PROTECTOR (SHOWN)**  
**D3281-4KCL FLOOR PROTECTOR (OPPOSITE)**  
LOCATION OF ENGRAVING



**D3281-1 FLOOR PROTECTOR**

**D3281-1 NOTES:**

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb

REV.	DESCRIPTION	BY	DATE																										
E	-3/4 NOW TRIMMED FLAT: RMV 0.25 BEVEL TO FACILITATE TRIMMING (ZN D6-3, D4-4)	CP	10.01.05																										
D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28																										
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09																										
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25																										
A	NEW ISSUE	CP	04.05.03																										
<table border="1"> <tr> <td>DESIGN</td><td>DP</td><td colspan="2" rowspan="2"> <b>DART AEROSPACE LTD</b>  HAWKESBURY, ONTARIO, CANADA </td></tr> <tr> <td>DRAWN</td><td>DP</td></tr> <tr> <td>CHECKED</td><td>DP</td><td>DRAWING NO.</td><td>REV. E</td></tr> <tr> <td>MFG. APPR.</td><td>DP</td><td>D3281</td><td>SHEET 1 OF 4</td></tr> <tr> <td>APPROVED</td><td>DP</td><td>TITLE</td><td>SCALE</td></tr> <tr> <td>DE APPR.</td><td>DP</td><td>FLOOR PROTECTOR</td><td>NTS</td></tr> <tr> <td>DATE</td><td>10.01.05</td><td colspan="2"> <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> </td></tr> </table>				DESIGN	DP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		DRAWN	DP	CHECKED	DP	DRAWING NO.	REV. E	MFG. APPR.	DP	D3281	SHEET 1 OF 4	APPROVED	DP	TITLE	SCALE	DE APPR.	DP	FLOOR PROTECTOR	NTS	DATE	10.01.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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DRAWING NO. D3281	TITLE FLOOR PROTECTOR	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3281-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>K</i>	MFG. APPR. <i>DL</i>	APPROVED <i>HL</i>		DE APPR. <i>HL</i>		
DATE 10.02.24	DATE 10.02.25	DATE 10/02/25	DATE 10.02.25		DATE 10.02.25		

### PURPOSE

ADD "D3281-xL08" MATERIAL OPTION. EXISTING PARTS TO BE IDENTIFIED AS "D3281-xL02"

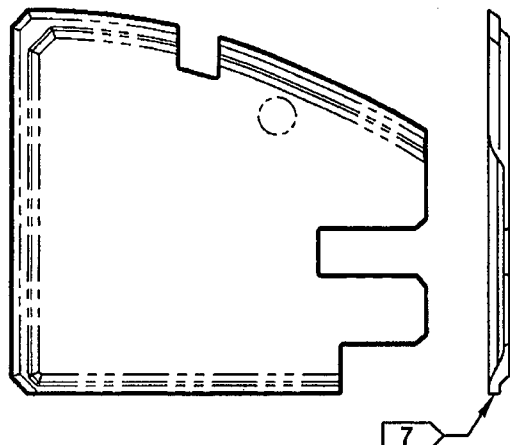
### CHANGE

D3281-xL08 PARTS ARE EQUIVALENT TO THE RESPECTIVE "-x" PARTS EXCEPT AS DETAIL BELOW. THE MATERIAL, IDENTIFICATION, AND WEIGHT NOTES ARE AMENDED AS FOLLOWS:

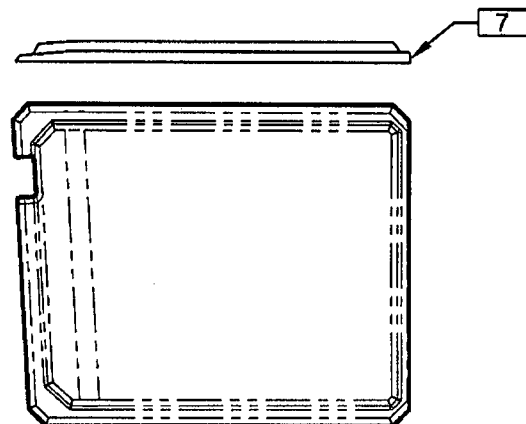
- 2) MATERIAL: -xL02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)  
 -xL08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)

- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-xLxx" AND B/N "Bxxxxx" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS.  
 FOR -xL08 PARTS, LOCATE ENGRAVING ALONG PERIMETER OF PART AS SHOWN.

- 8) WEIGHT: D3281-1L02/-2L02 = 0.95 lb D3281-1L08/-2L08 = 1.13 lb  
 D3281-1L02/-2L02 = 0.87 lb D3281-3L08/-4L08 = 1.05 lb



**D3281-1L08 FLOOR PROTECTOR (SHOWN)**  
**D3281-2L08 FLOOR PRETECTOR (OPPOSITE)**  
 LOCATION OF ENGRAVING



**D3281-3L08 FLOOR PROTECTOR (SHOWN)**  
**D3281-4L08 FLOOR PRETECTOR (OPPOSITE)**  
 LOCATION OF ENGRAVING

W/O  
56484

**RELEASED**  
2010-02-26  
*md*